

**Work Order ID 67257**

Monday, March 14, 2011 10:59:06 AM

*BHL/E*

Page 1

Item ID: D3414-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CDate: 11/03/14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100



Waterjet

FLOW CNC Waterjet

*304.100*

Memo

0.00

*B11-3-21*

1-Cut as per Dwg D3414-1

Dwg Rev: CProg Rev: C

2-Deburr if necessary

*8*

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

*B11-3-21*

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

8 u (03/21)

QC

Memo

0.00

Quality Control

130

Memo

0.00

Brake NC

1-Deburr

Brake NC

2-Form using DT8254 as per Dwg D3414

SB u (03/21)

8

140

Memo

0.00

Large Fab

1- Weld using location Jig DT9625 as per Dwg D3414  
A/R S.S. welding rod Batch: M107057

EL 11-3-21 88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item Name: Lug Assembly

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Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

175

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting:  
prime grey B: 117319  
spray paint delfleet blue B: 115985  
clear delfleet B: 117113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 67257**

Monday, March 14, 2011 10:59:06 AM



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Item ID: D3414-041

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Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 3/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

180



QC

Quality Control

Operation  
Description

QC1- Inspect Part Finish

QC4

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 420

0.00

11/4/28 80

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/4/29 80

11/6/28 80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

Monday, March 14, 2011, 10:59:02 AM

Work Order ID: 67257



Parent Item: D3414-041



Parent Item Name: Lug Assembly

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA 		Purchased		No		100	sf	187.4000	0.155	0.62	1.5		

304/316 0.100" Sheet

Location	Loc Qty	Loc Code
MAT19	187.4	
112290	2.5	
112611	29	
113062	123.9	113062
113077	32	

D3414-3



Manufactured

Lug

Location	Loc Qty	Loc Code
WA030	5	
66045	5	5

E

66944

3

3

(8)

11-3-21

EZ 11-3-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	67257
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414      Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      X Prototype

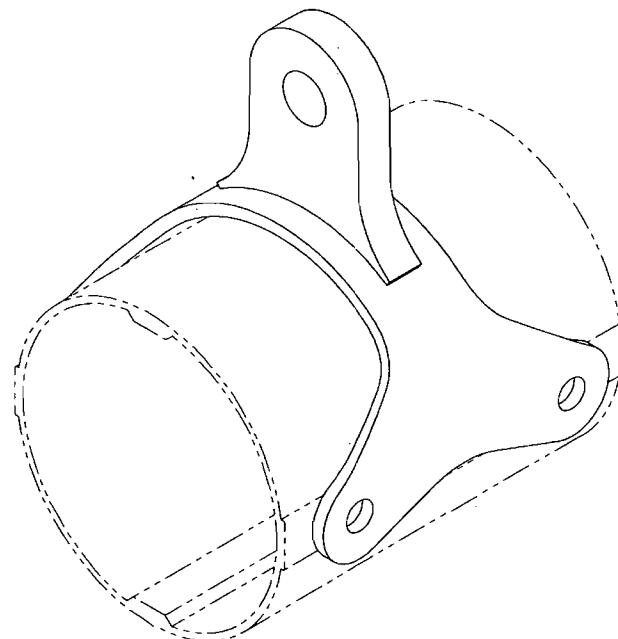
Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 11-3-21	Date: 11/03/21	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	<i>[Signature]</i> <i>[Signature]</i>



8 7 6 5 4 3 2 1

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG

**D3414-041 LUG ASSEMBLY****NOTES:**

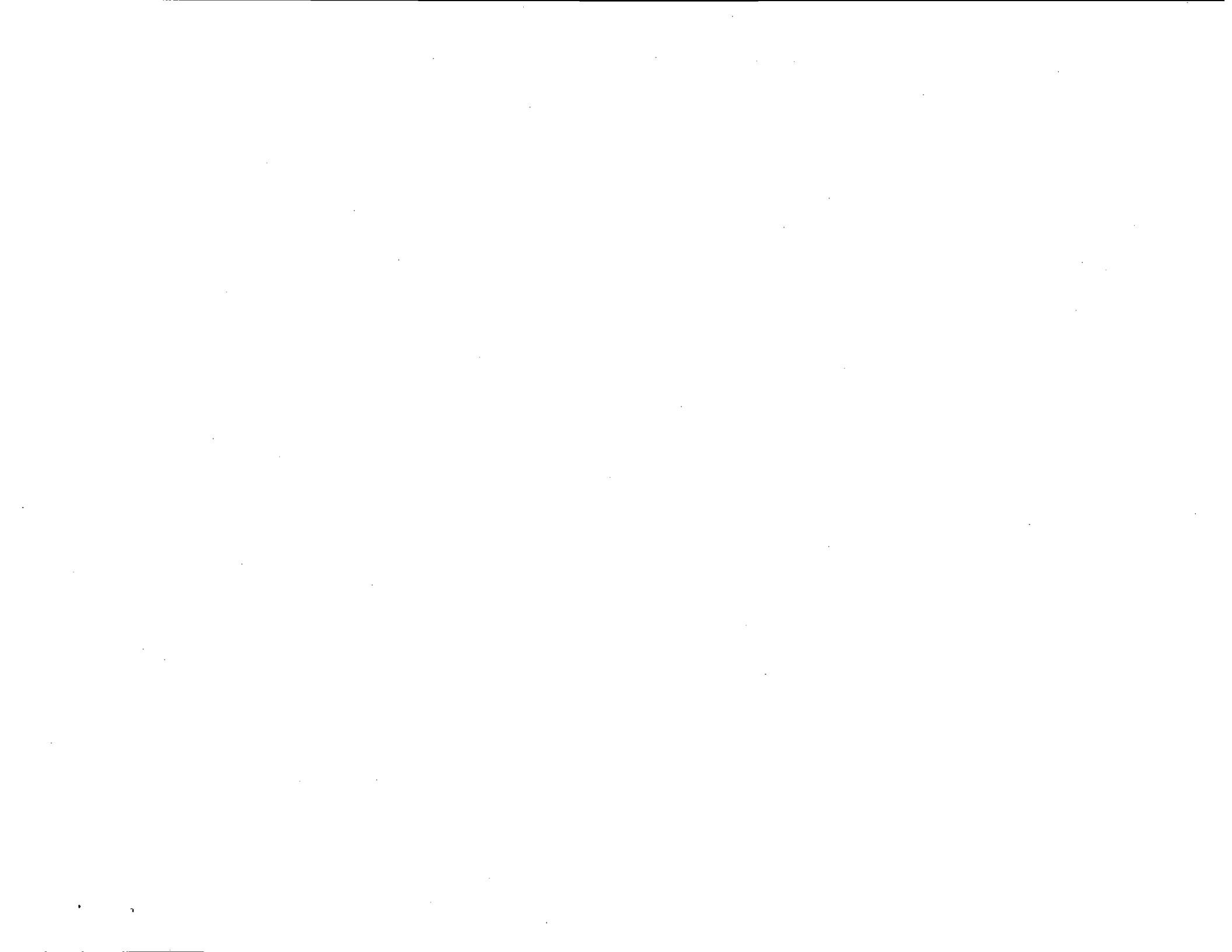
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES. 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 67257  
CL 110314

**RELEASED**  
*(5/16/06 W)*

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARD AND TRANSFERRED TO B7 SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

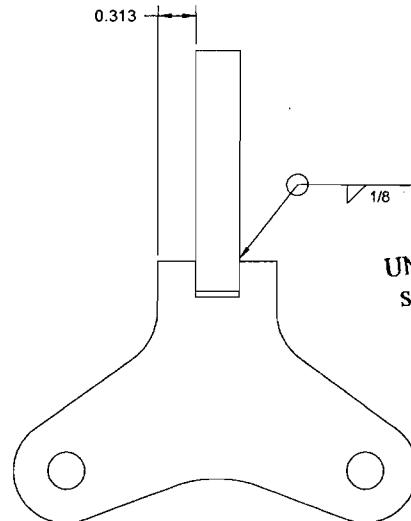
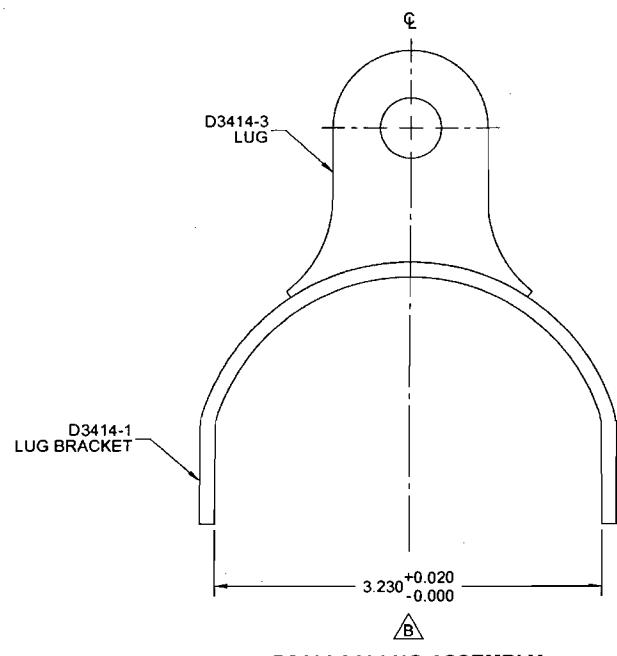
8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

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WORK ORDER  
6725

RELEASED  
09/06/17

DESIGN	CP	DART AEROSPACE LTD			
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA			
CHECKED	ED	DRAWING NO.			
MFG. APPR.	ED	REV. C			
APPROVED	ED	D3414			
DE APPR.	ED	SHEET 2 OF 3			
DATE	09.06.17	TITLE			
		LUG ASSEMBLY			
SCALE					
NTS					

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1 2 3 4 5 6 7 8





MOTORS

## ОГЛАВЛЕНИЕ